

ENGINE SPECIFICATIONS

PISTON PIN

Type	Full Floating
Pin length	2.963" - 2.973"
Pin diameter99955" - .99975"
Pin to piston clearance at room temperature0001" - .0005" loose
Inside diameter of connecting rod bushing - installed	1.0001" - 1.0006"
Piston pin to connecting rod bushing clearance00035" - .00105"

PISTON RINGS

Number of rings per piston	5
Location of oil rings	One above and one below piston pin
Ring end gaps - top compression007" minimum
2nd and 3rd compression014" minimum
4th oil control014" minimum
5th oil control007" minimum
Clearance of rings in grooves	
Top compression003" - .0045"
Top compression wear limit008"
2nd and 3rd compression002" - .004"
4th oil control001" - .0075"
5th oil control0015" - .0035"

CRANKSHAFT

Connecting rod journal diameter	1.9975" - 1.9985"
Main bearing journal diameter	2.497" - 2.498"
Connecting rod journal width	1.500" - 1.504"
Main bearing journal width	
Front bearing	1.557" - 1.567"
Intermediate bearings	1.318" - 1.326"
Center bearing	1.875" - 1.879"
Rear bearing	2.000"
Crankshaft end clearance003" - .009"
End clearance wear limit015"
Crankshaft journals may be ground to the following undersize010" - .020" - .040"
Fit of crankshaft gear on crankshaft001" - .003" tight

MAIN BEARINGS

Number used	5
Type	Replaceable precision
Inside diameter - with capscrews tightened to specified torque	2.4993" - 2.501"
Crankshaft main bearing journal diameter	2.497" - 2.498"
Bearing to journal clearance (with capscrews torqued to specifications)0013" - .004
Replace parts when bearing clearance exceeds007"
Main bearing length - front	
Intermediates	1.245" - 1.255"
Center	1.120" - 1.130"
Rear	1.870" - 1.872"
Undersize bearing available	1.745" - 1.755"
Bearing wall thickness - standard002" - .010" - .020" - .040"
Bearing bore in cylinder block cap in place and capscrews tightened to specified torque0995" - .1000"
Main bearing capscrew torque	2.6993" - 2.7000"
	120 - 130 ft. lbs.

Ford Tractor R134a Capacity Guide

Padhraic Smyth



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